

WORK ORDER 2012-09

Date opened: 26 March 2012

Project: Quick Release Cargo Basket Assembly
Type: Bell 206BBatch Quantity: 1 Complete Basket Assembly (81110-01)
Modified with Lid StepApproval: SH09-5
Drawing List: DCL811-3

Fabrication and Assembly Drawing(s)	Description
81110, Rev. 0	Basket Ass'y
81111, Rev. 0	Basket Body Ass'y
81112, Rev. 0	Basket Lid Ass'y
84255, Rev. 0	Handle Installation
84261, Rev. 0	Handle Bar Ass'y
84262, Rev. 0	Handle Bracket Ass'y
70405, Rev. 2	Front End Cutout

Complete material tracking information on attached pages.

Work Order pre-completion Inspection:

Project is on Approval Limitation Record:	Y ✓
Document Control List revision level matches (or exceeds) STC:	Y ✓
Drawings revision levels match Document Control List:	Y ✓
Purchase order or Work order source is recorded for each part/ass'y:	Y ✓
Tests and inspections specifically called out on drawings are complete:	Y ✓
Release tags associated with all fabricated parts are attached:	Y ✓
All mounting hardware and supplies are included:	Y ✓

List all non-conformities raised: _____

Welder Signature: _____


Date: _____

Inspector Signature: _____

Date: _____

Drawing: **81110** Revision **0**
 Assembly: **81110-01** **Cargo Basket Ass'y (Quick-Release, Long)**

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
1 Total	81110-01	Cargo Basket Assembly			
1	81111-01	Basket Body Assembly	Below		
1	81112-01	Basket Lid Assembly	Below		
1	84255-01	Handle Bar Installation	Below		
1	36280-01	Brace Assembly	9-2081 Brace	11078	
1	MS20001P4	Piano Hinge		11014	
1	81127-01	Placard	0.063 Sheet, 6061-T6 Aluminum	11102	
3	49205-14	Bumper	Argus Industries Bumper	11010	
A/R	CR3213-5-02	Cherry Rivet		11090	
8	CR3523-5-02	Cherry Rivet		11061	
4	CR3213-5-02	Cherry Rivet		11126	
4	40088-14	Fitting	Ancra	11121	
4	AN960-616	Washer		11077	
1	AN3-15A	Bolt		11077	
1	AN3-17A	Bolt		11077	
4	AN960-10	Washer		11088	
2	AN970-3	Washer		11052	
2	MS21044N3	Nut		11088	

Processes	Per	Mat'ls Used	Inspection	Signature
Riveting	AC43.13-1B	Cherry Rivets		
Final Inspection	Drawing 81110		✓	

Tag incomplete parts with Work Order # when stored between processes.

Tag complete parts / assemblies with Release Tag prior to storage.

Drawing: 81111 Revision 0
 Assembly: 81111-01 Basket Body Ass'y (Quick-Release, Long)

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
1 Total	81111-01	Basket Body Assembly			
A/R		Tube	4130 Steel, 3/4" x 0.035 Sqr. Tube	11117	
A/R		Tube	4130 Steel, 1/2" x 0.035 Sqr. Tube	11117	
4	80322-01	Hoop	4130 Steel, 1/2" x 0.035 Sqr. Tube	11117	
2	80324-01	Attachment Hoop			
. 1		Tube	4130 Steel, 1.0 x 0.065 Sqr. Tube	11049	
. 1		Tube	4130 Steel, 1/2" x 0.035 Sqr. Tube	11117	
. 1	80324-04	Cap	1018 Steel, 0.035" Sheet	9010	
. 1	80324-05	Insert	1018 Steel, 5/8 Dia Rod	10087	
1	84262-01	Handle Bracket Assembly	Below		
1	49215-01	Spacer	1018 Steel, 1/2" Rod	7007	
A/R	3/4-16F	Mesh	Expanded carbon steel	10112	

Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER70S-2		
Powder Coat	Drawing 81111			
Final Inspection	Drawing 81111			

Tag incomplete parts with Work Order # when stored between processes.

Tag complete parts / assemblies with Release Tag prior to storage.

Drawing: **81112** **Revision 0**
Assembly: **81112-01** **Basket Lid Ass'y (Quick-Release, Short, 57.25" long)**

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
1 Total	81112-01	Basket Lid Assembly			
A/R		Tube	4130 Steel, 3/4" x 0.035 Sqr. Tube	11117	
1	49216-01	Spacer	1018 Steel, 1/2" Rod	7007	
1	84262-01	Upper Handle Bracket Assembly	Below		
1	36204-10	Placard Bracket	1018 Steel, 0.035" Sheet	9010	
A/R	3/4-16F	Mesh	Expanded carbon steel	10112	

Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER70S-2		
Powder Coat	Drawing 81112			
Final Inspection	Drawing 81112			

Tag incomplete parts with Work Order # when stored between processes.

Tag complete parts / assemblies with Release Tag prior to storage.

Drawing: **84255** **Revision 0**
Assembly: **84255-01** **Handle Installation**

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
1 Total	84255-01	Handle Installation			
1	84261-01	Handle Bar Assembly	Below		
2	84267-01	Bracket	3/4" Delrin Sheet	WO2011-20	
2	36278-01	Spring (1 left, 1 right)	304 Stainless, 1/16" Dia Music Wire	11041	
2	36275-01	Bushing	SAE 660 Bronze, 5/16" Dia	11030	
4	AN3-11A	Bolt		11077	
2	AN3-12A	Bolt		11052	
12	AN960-10	Washer		11088	
6	MS21044N3	Nut		11088	


Processes	Per	Mat'ls Used	Inspection	Signature
Final Inspection	Drawing 84255			

Tag incomplete parts with Work Order # when stored between processes.

Tag complete parts / assemblies with Release Tag prior to storage.

Drawing: 84261 Revision 0
Assembly: 84261-01 Handle Bar Assembly

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
1 Total	84261-01	Handle Bar Assembly			
1	36277-01	Handle Bar	316 Stainless, 1.0 x 0.035 Rnd. Tube	10083	
2	36271-01	Lever	304 Stainless, 0.105 Sheet	10036	
2	36274-01	Bushing	304 Stainless, 7/16" x 0.065 Rnd. Tube	11057	
2	MS20615-4M3	Rivet		7039	


Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER308L		
Final Inspection	Drawing 84261			

Tag incomplete parts with Work Order # when stored between processes.

Tag complete parts / assemblies with Release Tag prior to storage.

Drawing: **84262** Revision **0**
Assembly: **84262-01** **Handle Bracket Assembly**

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
1 Total	84261-01	Handle Bracket Assembly			
4	84272-01	Bushing	4130 Steel, 5/16 x 0.058 Tube	11049	
4	36273-01	Lid Bracket	321 Stainless, 0.050 Sheet	10037	
2	36275-02	Support	304 Stainless, 5/16" Rod	11093	

Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER308L		
Final Inspection	Drawing 84262			


Tag incomplete parts with Work Order # when stored between processes.

Tag complete parts / assemblies with Release Tag prior to storage.

Drawing: **70405** **Revision 2**
Assembly: **70405-01** **Lid Step Modification**

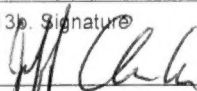
Qty Per	Part #	Description	Material	P.O./W.O.	Checked
1 Total	70405-01	Lid Step Modification			
A/R	70405-03	Tube	4130 Steel, 3/4" x 0.035 Sqr. Tube	11117	
1	70405-04	Tread Plate	3003 Aluminum Tread Plate, 0.063"	12009	
A/R	CR3213-4-2	Cherry Rivet		11126	

Note: Remainder of assembly listed on drawing 81112.

Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER70S-2		
Final Inspection	Drawing 70405			

Tag incomplete parts with Work Order # when stored between processes.

Tag complete parts / assemblies with Release Tag prior to storage.

1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No.	
4. Organization Name and Address AERO Design Ltd. – 2013 39 th Avenue NE, Calgary, Alberta, T2E 6R7					5. Work Order/Contract/Invoice WO 2012-09	
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work	
	Long Cargo Basket	81110-01	1	81101-05	New	
12. Remarks						
13a. Certifies that the items identified above were manufactured in conformity to:			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12 Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.			
<input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.						
13b. Signature 		13c. Approved Organization Number AMF 73-04		14b. Signature		14c. Approved Organization Number
13d. Name Jeff Clarke		13e. Date (dd/mmm/yyyy) 16 Apr 2012		14d. Name		14e. Date (dd/mmm/yyyy)
<p style="text-align: center;">Installer Responsibilities</p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>						

DUPLICATE